Rev E DAS 16 9-89 14/08/26

Work Order ID 115295

March-24-14 1:03:54 PM

115295

PRELIMINARY ISSUE

Page

Item ID: D4541-4 D4541-4

Revision ID: B115295

Item Name: Bracket, RH

Start Date: 3/24/14 **Start Qty:** 10.00 *10*

Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*

Reference:

Accept *N900040100* **Setup Start** *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____

QC: _____ **Date:** _____

Tooling: _____ **Date:** _____

SPC (Y/N): _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4541 Revision Nbr: Rev E	DAS 27 9-89								
100	DAS 10 9-89	0.00							
100						10	0		JM14-03-25
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1- Cut as per dwg (D4541-3f) Prog rev: PE2 Dwg rev: PE2								
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						10	0		JM14-03-25
QC	**Memo**	0.00							
Quality Control									

Work Order ID 115295

March-24-14 1:03:54 PM

115295

Item ID: D4541-4
Revision ID:
Item Name: Bracket, RH
Start Date: 3/24/14 **Start Qty:** 10.00 *10*
Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 DAS 27 9-89				10			
120		0.00 14/3/25				Inspect as per Dwg PEJ			
QC	**Memo**								
Quality Control									
130		0.00							14/03/25
130				DAS 30 9-89		10			
Small Fab	**Memo**	0.00							
Small Fab	Bend each tab as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00 DAS 27 9-89				10			
140		0.00 14/3/25				Inspect as per Dwg PEJ			
QC	**Memo**								
Quality Control									

Work Order ID 115295

March-24-14 1:03:54 PM

115295

Item ID: D4541-4
Revision ID:
Item Name: Bracket, RH
Start Date: 3/24/14 **Start Qty:** 10.00 *10*
Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
144	Chemical Conversion Coat per QSI005 4.1	0.00				10		3-25	
144 HandFinish Hand Finishing	Memo	0.00							
146	QC7-Inspect Chemical Conversion Coat	0.00 DAS 27 9-89				10			
146 QC Quality Control	Memo	0.00				Inspect as per DWG PFD			
150	Identify as per dwg & Stock Location: ST533	0.00				10 DAS 28 9-89			
150 Packaging Packaging	Memo	0.00							

MAR 26 2014

Item ID: D4541-4
Revision ID:
Item Name: Bracket, RH
Start Date: 3/24/14 **Start Qty:** 10.00 *10*
Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

MLJ 1403-26

MF 14-3-26

POSITIVE RECALL
EFFECTIVE 14.03.24 DAS AUTH LL
RELEASED 16 9-89 DATE 14/03/26

Release Dwg on Pen
Rev E DAS 27 9-89
14/3/26

Picklist Print

March-24-14 1:03:53 PM

Work Order ID: 115295 *115295*

Parent Item: D4541-4 *D4541-4*

Parent Item Name: Bracket, RH

Start Date: 3/24/14 **Required Date:** 3/25/14

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP REV:A 13.02.12 new issue DD verf:JLM
13.04.23 as per dwg revD DD verf:JLM
IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	379.2832	0.633	(7)			
M6061T6S.032									**				
6061-T6 Sheet 0.032"													

JM14-03-25

Location	Loc Qty	Loc Code	
MAT021	379.28317		
123483	8.57		
m125822	17		
m127272	119.43317		
m128054	234.28		128054

DART AEROSPACE LTD		Work Order:	115-295
Description:	Bracket	Part Number:	04541-4
Inspection Dwg:	04541 Rev: Rev 2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.098"	+0.004 -0.001	0.099"	—		V	JKM05
Ø 0.257"	+0.006 -0.001	0.259"	—		V	
0.344"	+/-0.010"	0.346"	—		V	
0.688"	"	0.690"	—		V	
1.005"	+/-0.030"	1.005"	—		V	
1.56"	"	1.572"	—		V	
0.320"	+/-0.010"	0.320"	—		V	
0.70"	+/-0.030"	0.716"	—		V	
28.6"	+/-0.100"	28.6"	—		I	JKM07
3.3"	"	3.3"	—		I	
0.032"	+/-0.010"	0.032"	—		V	

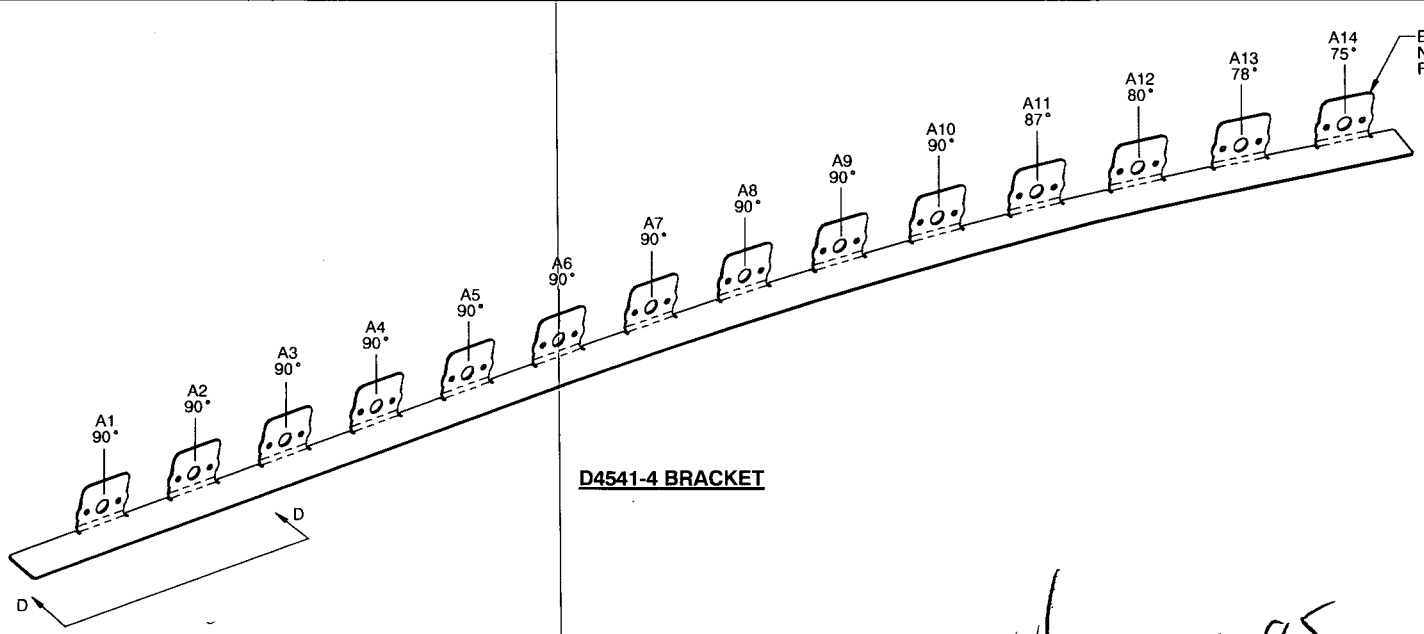
Measured by:	Jm
Date:	14-03-25

Audited by:	JAS 27 9-89
Date:	14-3-25

Preliminary Approval:	
Date:	

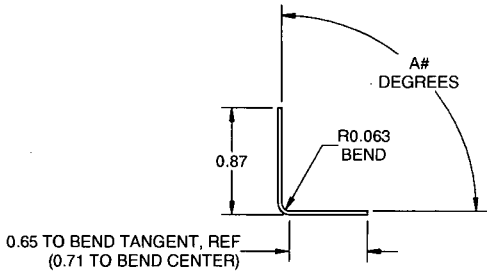
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

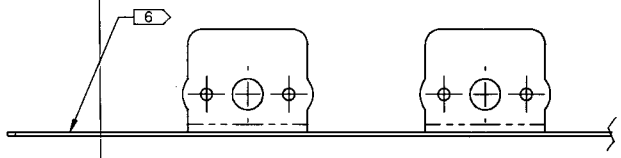
10.04.15



D4541-4 BRACKET

W/O 115295





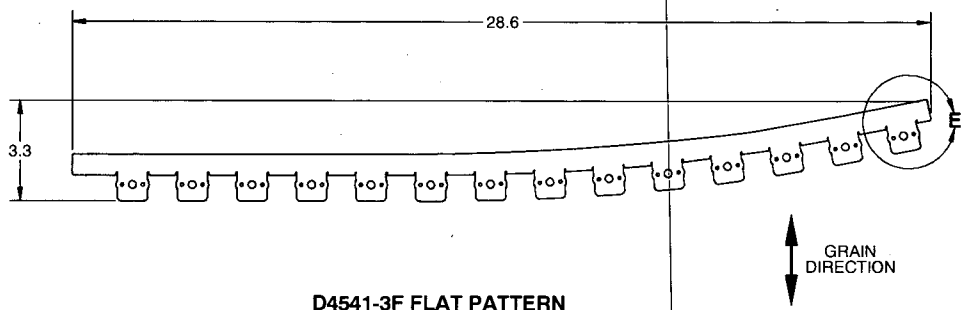
VIEW D-D
TYP TAB DETAIL
NOT TO SCALE

PRELIMINARY E2
14.03.07 (AJS)

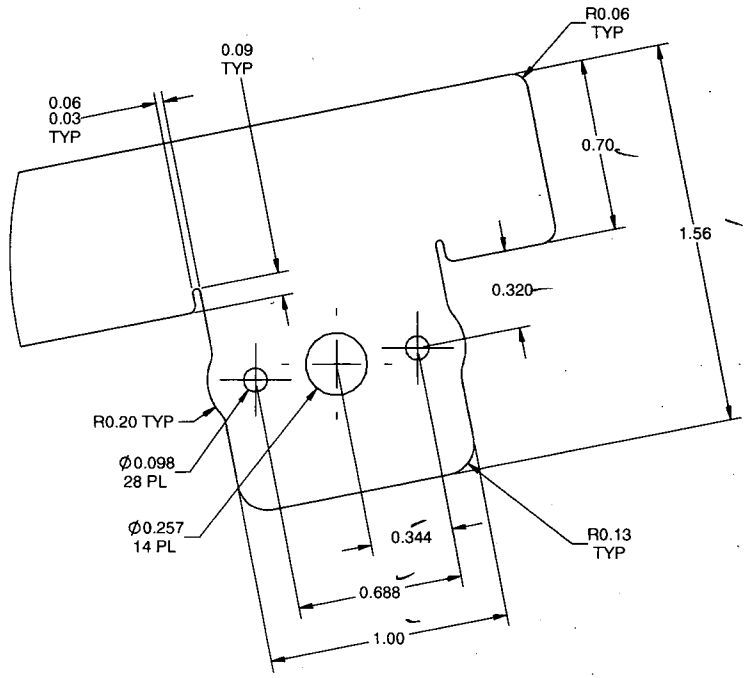
NOTES:
1) MATERIAL: MAKE FROM D4541-3F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.09 lbs

DESIGN	CP	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D4541 REV. PE2
MFG. APPR.		SHEET 6 OF 13
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	14.03.07	

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D4541-3F FLAT PATTERN



DETAIL E
TYP TAB DETAIL
SCALE 4X

PRELIMINARY E2
14.03.07 (AJS)

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.09 lbs
8) PROFILE PER DRAWING FILE "D4541-3F-REVE.DXF"

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE2
MFG. APPR.		D4541	SHEET 7 OF 13
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	14.03.07	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

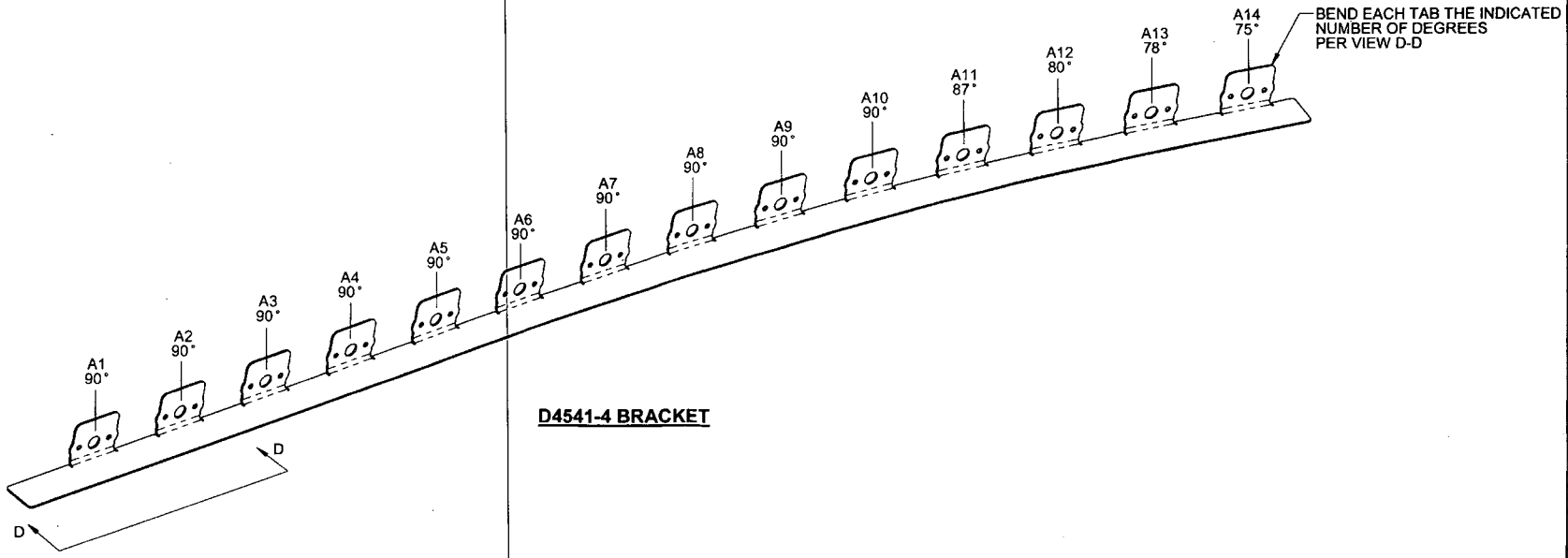
DART AEROSPACE LTD

Description:	Brackets	Work Order:	115295
Inspection Drawing:	D4541	Rev: P E2	Part Number: D4541-4

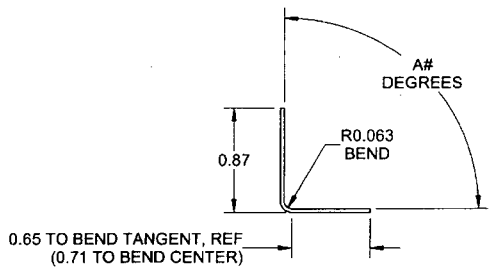
INSPECTION SHEET

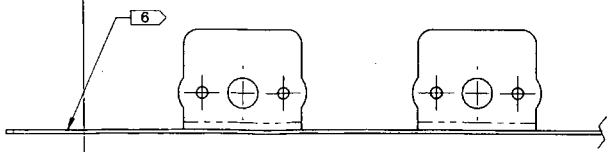
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.87	+/- .010	.877	/		V	SB-11
.65	+/- .010	.66	/		V	SB-4
90°	+/- 1/2°	90°	/		Protracter angle	SB-7
87°	+/- 1/2°	87°	/		"	SB-7
80°	+/- 1/2°	80°	/		"	SB-7
78°	+/- 1/2°	78°	/		"	SB-7
75°	+/- 1/2°	75°	/		"	SB-7

Measured by:	DAS 30 9-89	Checked By:	DAS 36 9-89	QC inspector DAS 27 9-89	Engineering Approval (*if necessa*
Date	14/03/25	Date	14/03/25	Date 14/3/25	Date



D4541-4 BRACKET





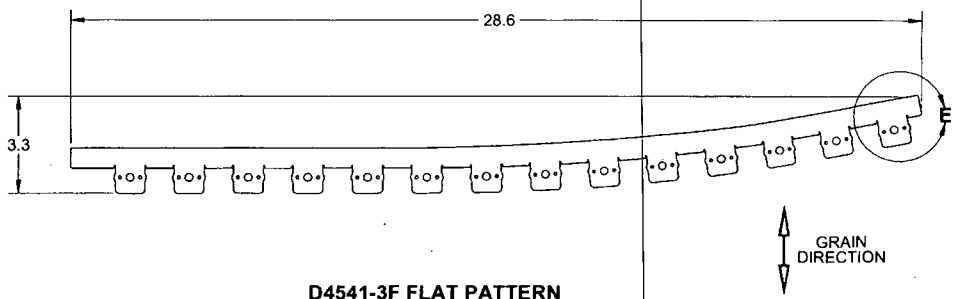
VIEW D-D
TYP TAB DETAIL
NOT TO SCALE

RELEASED
2014-06-26

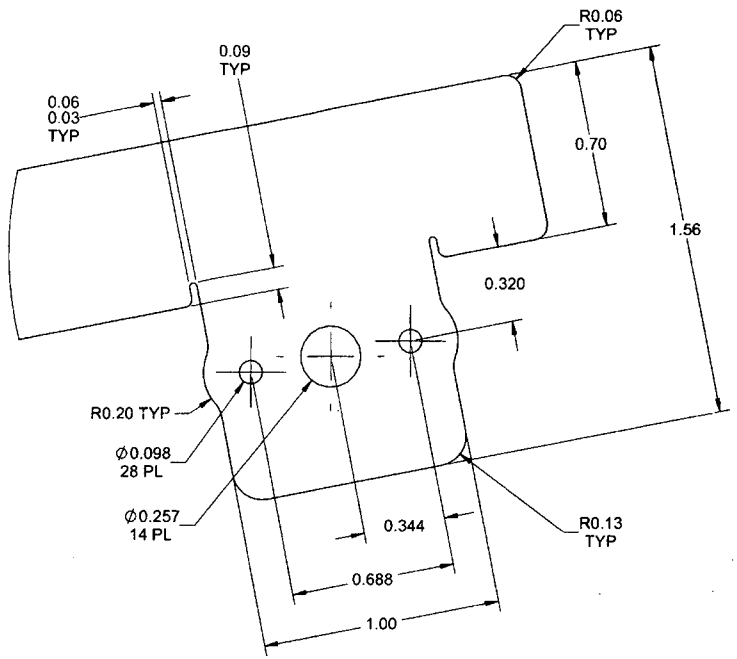
NOTES:
1) MATERIAL: MAKE FROM D4541-3F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.09 lbs

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	A.S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4541	SHEET 6 OF 13
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	14.03.07		

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D4541-3F FLAT PATTERN



DETAIL E
TYP TAB DETAIL
SCALE 4X

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.09 lbs
8) PROFILE PER DRAWING FILE "D4541-3F-REVE.DXF"

RELEASED
2014-05-26

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4541	SHEET 7 OF 13
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	14.03.07		

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